



Date: Thursday, 18/06/2009 2:46:50 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HAT BIN (BELL 206 L3/L4), IVORY
Job Number :	48639A	Part Number :	D38501KIV
Estimate Number :	13678	Drawing Number :	D3850
P.O. Number :		Project Number :	
This Issue :	18/06/2009	Drawing Revision :	SC 06
Prsht Rev. :	NC	Material :	MKYD6185S125P362015
First Issue :	/ /	Due Date :	24/06/2009
Previous Run :	43955	Qty:	2 Um: Each
Written By :			
Checked & Approved By :			
Comment :	Est. Rev. A. 08.12.03 New Issue DL Est. Rev. B 09/04/15 Thicker Material verified by:EC Est Rev C Add Colour Code 09/06/02 DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

0.0	MKYD6185S125P362015	6185 KYDEX .125"
-----	---------------------	------------------



Comment: Qty.: 11.4144 sf(s)/Unit Total : 22.8288 sf(s)
 6185 Kydex .125" Ivory

110426

BB 09/06/18

1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/18 (x2)

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

Wk 09/06/18

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3850 and folio (FTA9338 Prototype) using tool DT 9338

Dwg. Rev. C

Folio Rev. B

BB 09/06/18 (x2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (BELL 206 L3/L4), IVORY

Job Number: 48639A

Part Number: D38501KIV

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

JB 09/06/18 (X2)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

W 09/06/18

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

W 09/06/18

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

W 09/06/18

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/18 (X2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

INTHERMOFORMING
Waiting Packaging

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18
H

Job Completion



W 09/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3850-1 KIV PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 10.01.24

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>48639A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.06.24	6	Drawn portion of hat bin is thin and soft	<u>AS</u> 055042 09.06.24	Reinforce affected sections per attached instruction based on TR-D407-791 Rev.12	<u>AS</u> 07/06/24	<u>S</u> 02/06/24	<u>AS</u> 055042 09.06.24	<u>S</u> 07/26/24

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40639A
Description:	Part Number: D3850-11
Inspection Dwg: D3850 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL

Date: 09/06/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55"	MIN	0.60	✓			
0.055	MIN	0.106	✓			
0.030"	MIN					See Attached

Measured by: DL

Date: 09/06/24

Audited by: BB

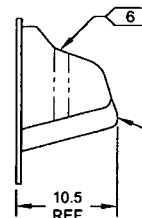
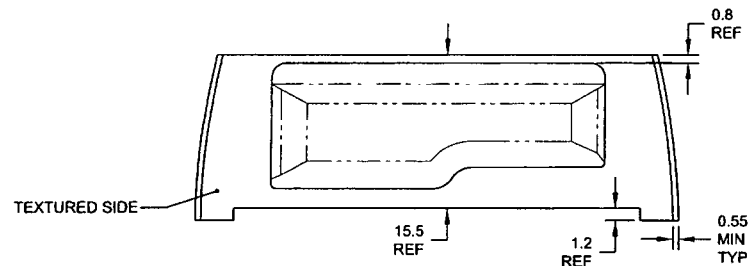
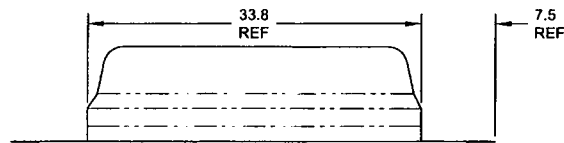
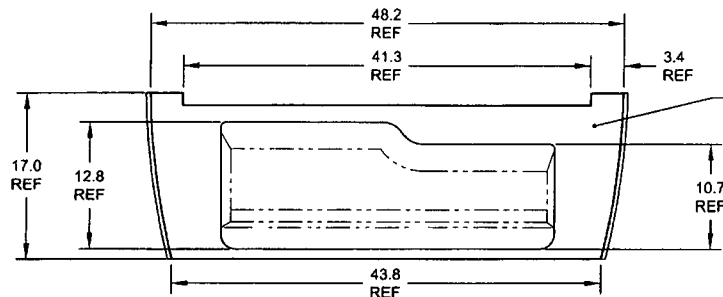
Date: 09/06/24

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Handwritten signature]



MIN FLANGE
THICKNESS
0.055






MIN THICKNESS IN
DRAWN PORTION IS
0.030

D3850-1 HAT BIN (BELL 206 L3/L4)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3850-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3850-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3850-1KIV AND ADD STEEL GRAY P/N D3850-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3850	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 L3/L4)	NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
01/05/22

WLO
48639A

Ref Work order NRE sheet

With reference to Test Report, TR-D407-781-1 Rev. A, the following may be performed to reinforce the drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.

Kydex 6185 reinforced with 9 oz cloth using Hysol 9330 A/B and ATH208
Procedure:

- 1) Abrade smooth side of Kydex 6185 with scotchbrite and clean with acetone
- 2) Mix Hysol 9330 – Part A to Part B – 100% to 33% by weight in accordance with manufacturer's instructions

Hysol 9330 (2 part system)

BATCH # M 112095

- 3) Mix item 2) with ATH208 (Aluminum TriHydrate) at 50% by weight

ATH208

BATCH # M 110065

Ex:

100 grams of Hysol 9330 Part A + 33 grams of Hysol 9330 Part B = 133 grams of Hysol 9330

Therefore, use 133 grams of ATH208

- 4) Saturate 1 layer of 7781 9oz glass Cloth (item # FG778150550ROL) with mixture of Hysol 9330 and ATH208

9oz glass Cloth

BATCH # M 111166

- 5) Apply item 4) to reinforce drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.
- 6) QC 5

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4369A